0.00

0.00

RY 13-2-6

120

QC

Quality Control

OC8- Inspect parts - second check

Memo

												DQA:	Da	ite:	`
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE		•		•	
	_											QA Closed:	Da	te:	
Work Orde	Vork Order:					DISPOSITION				AGAINST D	ŀΕΓ	PARTMENT	PROCESS		
			Rework]		Skid-tube	Crosstube			Water Jet		Engineering			
Part N	Part No.				Scrap] .	1	Machining	Small Fab		Pro	d. Eng. Coor.		Quality	
			Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other			
NCR No.			Work Order Update]		Large Fab	Composite	╛		Supplier					
Root					Descri	iption of work order update		Initial	Ac	tion	٦	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data							Ī								
Equip/Tooling															
Operator															
Material							İ								
Setup						•									
Other															
Process															
Supplier											ı				
Training					•						-				
Unapproved															-
						F	AUL	T CATE	GORY						-
Landi	ng (Gear				General		_		_		_			
	Bending			Bend		Grain				Ovalized			Pressure/Forced		
		Centre No	ot Concer	ntric to	o/s	BOM/Route] Hardwa	re			Over/Under tolerance			Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorrect		Weld	
		Crushed/	Crimped,			Burrs		Instruct	ions Incomplete/	/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabelec

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Page 2

January-21-13 10:20:40 AM Item ID: D3204-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Tube 1/16/13 **Start Qty: 10.00 Start Date: Cust Item ID:** Required Date: 1/29/13 Req'd Qty: 10.00 **Customer:** Reference: Run Process Plan: Date: Tooling: Date: Approvals: Stop Date: SPC (Y/N): Date: Reject Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Sequence ID/ Description Qty Number Stamp Code Qty **Work Center ID Run Hours** Identify as per dwg & Stock Location: W/4 00 - 0.00 130 *120* 10 & 13-2-13 Packaging 0.00 Memo *****STOCK IN LARGE FAB***** Packaging 13/2/14 PT MF 13-2-14 QC21- Final Inspection - Work Order Release 140 0.00 *140* 0.00 QC Memo Quality Control

NCR:	Yes	1	Nο

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	

											QA Closed:	Date		
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No				Rework Scrap Use-as-is Work Order Update		Machining Small Fab Thermoforming Finishing		Crosstube Small Fab Finishing Composite	b Prod. Eng. Co Rec/Store/Packag		Engineering Quality Other			
Root					Descri	ption of work order update		nitial	Ad	ction	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	į	cription	Date	Verification	QC Inspector	
Doc/Data				T			· · · · · · · · · · · · · · · · · · ·							
Equip/Tooling														
Operator							İ							
Material]	
Setup														
Other	L													
Process	<u> </u>	·												
Supplier			1					•	1					
Training	\sqcup													
Unapproved		,									1	<u> </u>		
l and:							AUL	T CATE	GORY					
Landi		Bending				General Bend		Grain		Γ	۱		٦. ،	
		Centre No	at Concor	stric to)/s	BOM/Route	\vdash	Grain Hardwa		-	Ovalized		Pressure/Forced	
	 	Cracks	or Concer	itire to),3 	Broken/Damaged	_		ion Incomplete	-	Over/Under Part Incorred	<u> </u>	Temperature/Cure Weld	
•	\vdash	Crushed/0	Crimned		-	Burrs			ions Incomplete	/Unclear	Part Lost/Mi	 	Wrong Stock Pulled	
	-	Cuffs	ermpea.			Contamination		Mainte		Officieal	Part Moved	13361 B		
		Heat Trea	ıt			Countersink	_	Mislabe			Positioned V	Vrong		
		Inspection		Tube		Cut Too Short	-	Misread			Power Loss/		Other	
		Ripples in	•			Drill Holes		Offset		!	J. 3s. 2333,		100.00	
		Torque W		xtrusio	,	Drawing	\vdash		Calibration		· · · · · · · · · · · · · · · · · · ·			
		Turning S	equence			Finish	-		Sequence					
		Wave/Tw	ist in Tub	e		Folio		Outside Dimensions			-			

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Page 1

Work Order ID:

95965

Parent Item:

D3204-1

Parent Item Name:

Tube

Start Date: 1/16/13

Required Date: 1/29/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP:

B04.06.09Change Step 6: remove Steps 7 & 8KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Oty	Qty Issued	Date Issued	Status	
M6061T6T0.750W.125		Purchased	No		··· » — ···· • • ··· • ·· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ··· • ·· • ·· • ·· •	100	f	39.4500	0.52	5.473684				-
6061-T6 RD Tube .750 x .	125W													

Location Loc Qty Loc Code MAT015 39.45 39.45

MP 13/02/05

										DQA:	Date:	,		
NCR:	Yes / N	lo			WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE					
_					_					QA Closed:	Date:			
Work Orde	or.				DISPOSITION			``	AGAINST DE	AGAINST DEPARTMENT/PROCESS				
Work Orac					Rework	7		Skid-tube	Crosstube	1	Water Jet	Engineering		
Part 1	Part No.			Scrap	1	1	Machining	Small Fab	-	d. Eng. Coor.	Quality			
				Use-as-is	1	1	noforming	Finishing	4	re/Packaging	Other			
NCR I	NCR No.			Work Order Update]		Large Fab	Composite]	Supplier				
			-	1						· · · · · · · · · · · · · · · · · · ·				
Root					iption of work order update	Į.	Initial		tion	Sign &				
Cause	Dat	e Step	Qty		or Non-conformance	Ct	nief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data					;									
Equip/Tooling														
Operator										1				
Material		İ												
Setup														
Other	\dashv													
Process	\square										<u> </u>			
Supplier														
Training	\vdash					}								
Unapproved			_L	<u> </u>		- 4111	LT CATE	CORY						
Landi	ng Gear				General	AUI	LICATE	<u>JORT</u>				 		
Land	Bendi	na		Г	Bend	Г	Grain			Ovalized		Pressure/Forced		
		ਾਠ e Not Conce	ntric to		BOM/Route	\vdash	Hardwa	uro.	-	Over/Under	tolerance	Temperature/Cure		
	Crack		inti ic to	°''	Broken/Damaged	\vdash	4	ion Incomplete	-	Part Incorre	<u> </u>	Weld		
	_	s ed/Crimped	1	-	Burrs	\vdash	- `	•	Unclear	Part Lost/Mi		Wrong Stock Pulled		
	Cuffs	cu) ci iiiipeu	١.	\vdash	Contamination	\vdash	Instructions Incomplete/Unclear Maintenance			Part Moved		Tairoug prock Lausa		
	Heat	Treat			Countersink		Mislabe		-	Positioned V				

Out of Cal bration

Out of Sequence

Outside Dⁱmensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order:	95965
Description: Tube	Part Number:	D3204-1
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	0.451	✓		Vern	CWC-02
Ø0.500	+/-0.010		/		Vern	(WC-02
6.110	+/-0.010	0.501 6.118f	V		vern	(WC-02 CWC-02
	·				1	
						-
	5				v.	

Measured by: M.P	Audited by:	Prototype Approval:	N/A
Date: /3/02/05	Date: (3 · 2 · 6	Date:	N/A

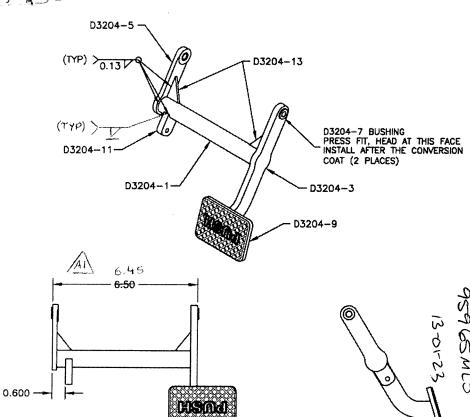
Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue	KJ/JLM ,	1
В	06.03.21	Dwg Rev update	KJ/JLM	





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Α	ı	04.01.27	NEW ISSUE	
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AI G 5 05.07.15 6.45 WAS 6.50

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125) 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 4) MATERIAL: AISI 303 SS (M303R)
 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
 7) WELD ASSEMBLY PER QSI 004
 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 11) ALL DIMENSIONS ARE INCHES

- 11) ALL DIMENSIONS ARE INCHES

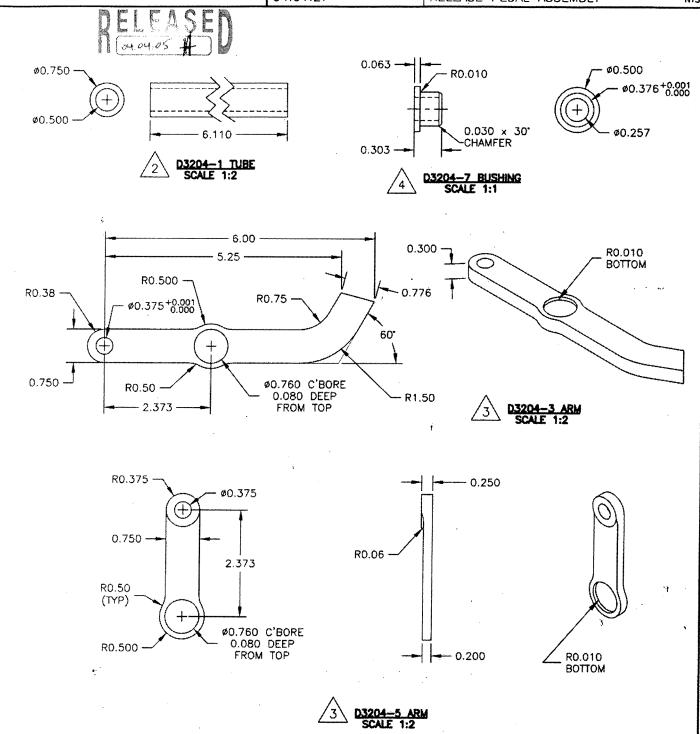
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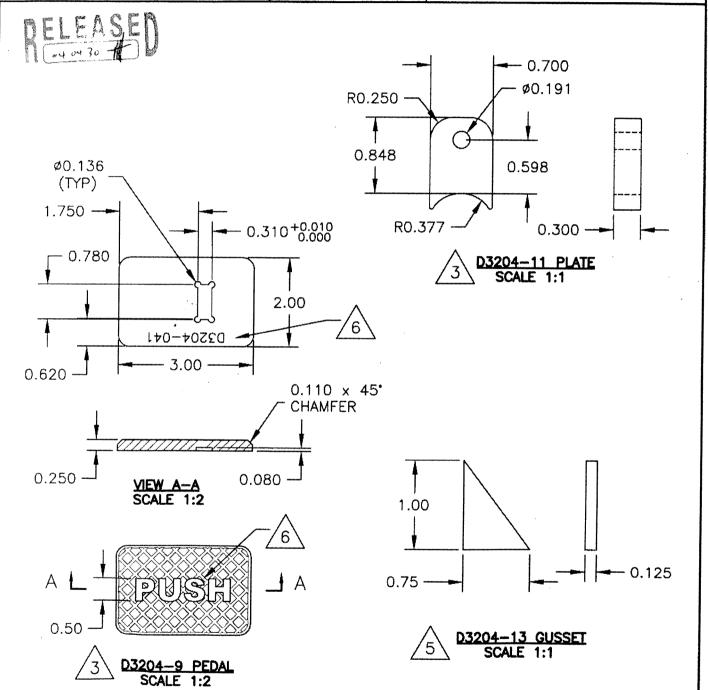


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